



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB072610-H-00
Job Sheet 179021



Part No: RB072610-H-00

Job Qty: 1 ea

Part Name: Ground Handling Wheels, Universal (Hydraulic)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/12/18

Job Tracking No:

Due Date: 7/10/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RB072610-H00 Rev.5 IPP Rev. A 18.06.07 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs	7/10/18	7/10/18	0.00	0.00	Purchasing		JUL 1 9 2018
110	Packaging	1 pcs	7/10/18	7/10/18	0.00	0.00	Packaging2		JUL 1 9 2018
120	QC	1 pcs	7/10/18	7/10/18	0.00	0.00	QC6		38
121	Small Fab	1 pcs	7/10/18	7/10/18	0.00	1.00	Small Fab-5		38
122	QC	1 pcs	7/10/18	7/10/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	7/10/18	7/10/18	0.00	0.00	Packaging3		38
140	QC21-FG	1 Ea	7/10/18	7/10/18	0.00	0.00	QC21		38

Part Op 100 - Issue P/O: 240172 MANUFACTURE RB072610-H-00 AS PER DWG Supplier: METEC Certificate of conformity Descriptions: is required

121 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 as per DWG. Deburr.

3-Rivet placard 4-Install labels

130 - Pack in crate 29"x20"x20" as per DWG. sheet 1.

JUNE 12 2018 x1 R L

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB072610-H-00P	GROUND HANDLING WHEELS	1 pcs (1 ea)	100-Purchasing	5094658
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	121-Small Fab	5076900
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	121-Small Fab	5021040
RBD3309-1	Label, Remove Before Flight	1 Ea (1 ea)	121-Small Fab	5062872
RBD3309-3	Label, Grease Slides	2 Ea (2 ea)	121-Small Fab	5062873
				5089444

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB072610-H-00P	1	0	0
121-Small Fab	97524A032	4	387	0
	RB41011	1	891	0
	RBD3309-1	1	8	0
	RBD3309-3	2	4	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S094064



Part: RB072610-H-00

Job No: 179021

Serial No/Batch: S094064

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 07/19/18

2-10

88

03-0

24-1

8E

06-0

7S

02-0

47

35

74-0

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SKID ATTACHMENTS SOLD SEPARATLY (2 ATTACHMENTS PER KIT)



RB072610-H-A
EC SKID ATTACHMENT
FOR EUROCOPTER
AS350/355 & EC120



RB072610-H-B
BELL SKID ATTACHMENT
FOR 206L, 407, & 427



RB072610-H-C
BELL & MD SKID ATTACHMENT
FOR BELL OH-58 & MD 500



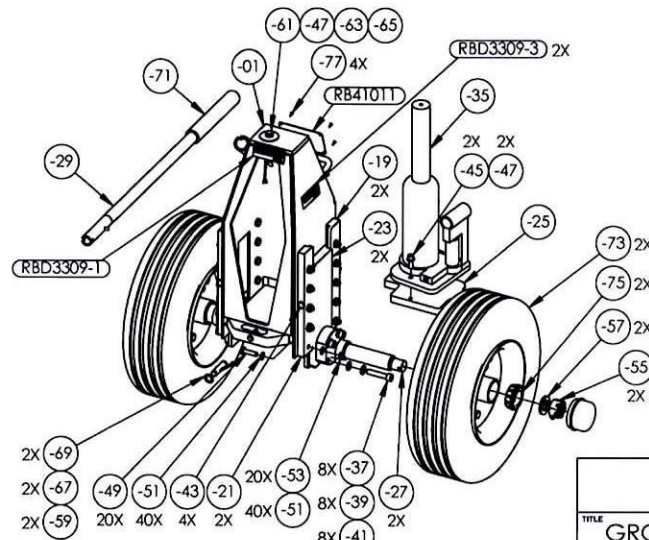
RB072610-H-D
BELL & HILLER
SKID ATTACHMENT
FOR BELL 47 &
HILLER 12 MODELS



RB072610-H-E
MD SKID ATTACHMENT
FOR 600 & 900 MODELS
(BOEING ROTOR CRAFT)

			REVISIONS		DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION					
1		SHT 1: ATTACHMENTS CHANGED TO REF -23 QTY FROM 2 TO 4. -37 FROM 5/16-18 TO 5/16-24. -61 FROM 3/4 TO 1. -65 FROM 5/16 TO 7/16. SHT 5 SHORTENED FROM 5.06 TO 4.62 SHT 12 5/16-18 CHANGED TO 5/16-24. ADDED R.06 TO 2 EDGES. SHT 14 CHANGED LENGTH FROM 5.282 TO 6.06. SHT 16. REMOVED PINCHED NOSE. ADDED CUT OUT AND 0.735 OVER 3 INCHES. SHT 18 ADDED THIS SHEET FOR CORRECT LENGTH!			3/9/2011	JAG	
2		SHT 2-4 INCREASED HEIGHT BY .50. SHT 5 ADDED 1/4 RADIUS. SHT 10-12 CHD TO BLACK ANODIZE FROM GOLD. SHT 14 CORRECTED 3/4-16 UNF CALL OUT			2/23/2012	JAG	RW
3	16-0087	-01 DELETED BEVEL WELD FRONT & BACK. ADDED FILET WELD 2X. CHD FINISH WAS POWDER COAT FORREST 1-5920 SYVYELLOW RIBBON IS POWDER COAT YELLOW FED #13538. -08 ADDED DIM 2X. 25 TWO PLACES. -09 CHD DIM WAS 2.80 S 2X R.26. WAS 1.316 S 1.32. WAS .658 S .66. WAS 1.20 2X S 2X. 12. WAS .445 S .45. WAS 0.391 S 0.391 THRU ALL. -11 CHD DIMS WAS 2.844 S 2.84. WAS 2.52 S 2.54. WAS 0.252 S 0.25. -19 & -21 DELETED DIMS 3.000. 4.500. AND 6.000. CHD DIM WAS 1.500 S 1.500. CHD ENGRAVE NOTE WAS ENGRAVE PART NO. 3/16 LETTERS IS ENGRAVE P/N. -23 CHD DIM WAS .505 S .535 +.015-.000. -25 & -29 CHD FINISH WAS POWDER COAT FORREST 1-5920 SYVYELLOW RIBBON IS POWDER COAT YELLOW FED #13538. -27 CHD DIMS WAS .772 S .77. WAS 1.25 S .13. WAS 0.680 S 0.65. CHD ENGRAVE NOTE WAS ENGRAVE PART NO. 3/16 LETTERS IS ENGRAVE P/N. -31 CHD DIM WAS 0.188 S 0.188 THRU ALL. CHD ENGRAVE NOTE WAS ENGRAVE PART NO. "RB072610-H-29. 3/16 LETTERS IS ENGRAVE "RB072610-H-29". -35 DELETED TACK IN TWO PLACES WELD CALLOUT. ADDED CRATE TO BOM. -75 ADDED TO BOM. ADDED RB03309-1 & RB03309-3 TO BOM.			8/1/2016	RJC	JAG
4	17-0033	-01 CHD DIM WAS (5.06) S (5.25). REMOVED DIM (1.02). -03 CHD DIM WAS 12.10 S 12.05. WAS 3.22 S (3.05). WAS 7.27 S 7.33. WAS 13.03 S 12.98. WAS 14.1 S 14.3. WAS 10.2 S 10.4. WAS (2X 10.3) S 2X 10.3. WAS 7.26 S 7.30. WAS 5.74 S 5.63. WAS 12.75 S 12.71. WAS 5.22 S 5.05. ADDED DIM 2X. 1.42. 1.75. 2X 10.4. -08. REMOVED DIM (2X .6). 2.56. 2X .81. -08 CHD DIM WAS 2X .25 S 2X .19. WAS 3.24 S 3.13. WAS 5.30 S 5.49. WAS 5.30 S 3.03. WAS 2.43 S 2.38. WAS 10.4 S 11". WAS 4X .50 S 4X .500. WAS 1.01 S 1.01. REMOVED DIM 1.2". 3.00. 2.75. 1.22. 10.4". ADDED DIM 2X 11". 5.64. 1.97. 3.75. ADDED FLAT PATTERN SHEET. -09 CHD DIM WAS .55 S .55. ADDED DIM 1.65. REMOVED DIM (1.27). -66. -25 REMOVED DIM 3.125. CHD DIM WAS 4X 8.25 S 4X 8.25. -27. CORRECTED REV 3 NOTES. REPLACE DIM 0.65. 13. .77 WITH .90. MIN THREAD RELIEF. -29 ADDED NOTE "INK STAMP P/N". -31 REMOVED NOTE "INK STAMP "RB072610-H-29". -35 CHD DIM WAS 1.563 S 1.564.			2/8/2017	SM	JAG
5	17-0144	-08 ADDED DIM 2X 0.385 +.020-.000. -18 CHD DIM WAS 0.38 S 0.375 +.005-.010 (S.F. .05). WAS 1.43 S 2X 1.43. -31 CHD DIM WAS 0.188 THRU ALL S 0.188 +.005-.000 THRU ALL. -41 CHD B/O INFO WAS 1/4-20 X 1 #92865A542 S 1/4-20 X 3/4 #92865A540. -77 ADDED.			6/20/2017	RJC	JAG

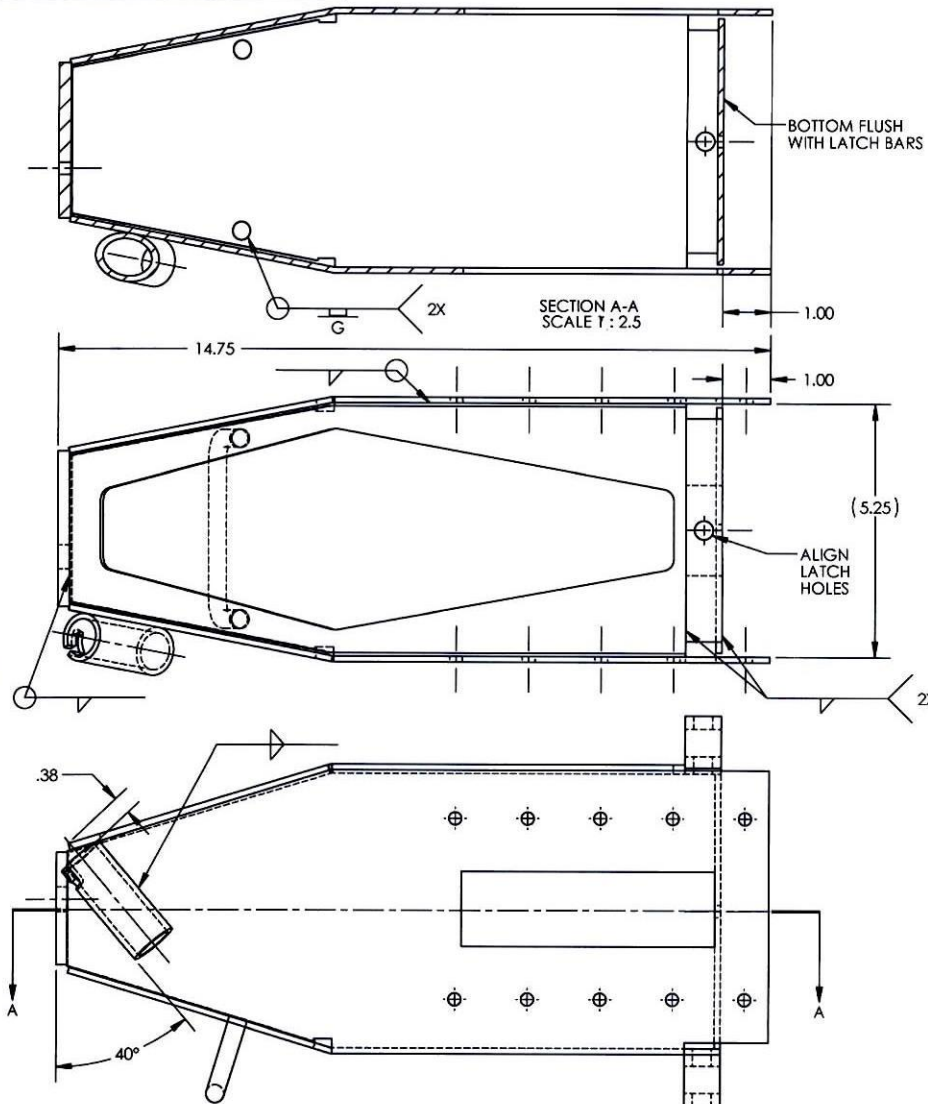
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-01	2	HOUSING WELDMENT			2
	1		-03		FRONT	A36/1018/1020 HR		3
	1		-05		3 SIDED FRAME	A36/1018/1020 HR		4.5
	2		-09		LATCH BAR	A36/1018/1020 HR		6
	1		-11		BOTTOM	A36/1018/1020 HR		7
	1		-13		TOP	A36/1018/1020 HR		8
	1		-15		HANDLE	1018/1020 CR		9
	1		-17		LOCK TUBE	DOM		10
			-19	4	LEFT SLIDE CLAMP	6061		11
			-21	4	RIGHT SLIDE CLAMP	6061		12
			-23	4	SLIDE	6061		13
			-25	2	JACK PLATE	4140/4142		14
			-27	4	SPINDLE	6061		15
	X	1	-29		HANDLE BAR WELDMENT			16
	1		-31		HANDLE BAR	DOM		17
	1		-33		DOWEL PIN	STEEL	03/16 X 1 (MCMASTER-CARR #98381A510)	16
			-35	2	3 TON HYDRAULIC JACK	NORCO MODEL NO. 76503A (MODIFIED)		18
		B/O	-37	16	SOCKET HEAD CAP SCREW	STEEL, PLATED	5/16-24 X 1-1/2 (MCMASTER-CARR #91251A387)	1
		B/O	-39	16	FLAT WASHER	STEEL, PLATED	05/16 ID AN960-516	1
		B/O	-41	16	SPLIT LOCK WASHER	STEEL	05/16 ID (MCMASTER-CARR #91102A755)	1
		B/O	-43	8	ZERK FITTING	STEEL, PLATED	1/4-28 (MCMASTER-CARR #1095K44)	1
		B/O	-45	4	SOCKET HEAD CAP SCREW	STEEL, PLATED	1/4-20 X 3/4 (MCMASTER-CARR #91251A540)	1
		B/O	-47	6	SPLIT LOCK WASHER	STEEL, PLATED	01/4 ID (MCMASTER-CARR #91102A750)	1
		B/O	-49	40	HEX HEAD CAP SCREW	STEEL, PLATED	1/4-28 X 1 (MCMASTER-CARR #92865A008)	1
		B/O	-51	80	FLAT WASHER	STEEL, PLATED	01/4 ID AN960-416L	1
		B/O	-53	40	NYLOCK NUT	STEEL, PLATED	1/4-28 (MCMASTER-CARR #9495A210)	1
		B/O	-55	4	SLOTTED HEX NUT	STEEL, PLATED	3/4-16 (MCMASTER-CARR #95030A270)	1
		B/O	-57	4	FLAT WASHER	STEEL, PLATED	03/4 ID (MCMASTER-CARR #97669A400)	1
		B/O	-59	4	COTTER PIN	STEEL, PLATED	01/8 X 1-1/4 (MCMASTER-CARR #9838A185)	1
		B/O	-61	2	HEX HEAD CAP SCREW	STEEL, PLATED	1/4-20 X 3/4 (MCMASTER-CARR #92865A540)	1
		B/O	-63	2	FENDER WASHER	STEEL, PLATED	01/4 ID, 01-1/4 OD (MCMASTER-CARR #91090A109)	1
		B/O	-65	2	DRILL BUSHING	STEEL	01/4 ID X 03/8 O.D. X 1/4 (MCMASTER-CARR #8491A099)	1
		B/O	-67	4	CLEVIS PIN W/HAIR PIN	STEEL, PLATED	03/8 X 1-1/2 (MCMASTER-CARR #97245A682)	1
		B/O	-69	4	FLAT WASHER	STEEL, PLATED	03/8 AN960-616L	1
		B/O	-71	2	HANDLE BAR GRIP	PLASTIC	03/4 X 6 MCMASTER-CARR #9282K123	1
		B/O	-73	4	WHEEL ASSEMBLY	MHS CASTERS #TC-070-386-1TR8		1
		B/O	-75	4	TAPERED-ROLLER BEARING	STEEL	01" SHAFT, TRADE #L4643 (MCMASTER-CARR #6678K12)	1
		B/O	-77	4	#2 DRIVE SCREW	STEEL	#2 X 1/4 (MCMASTER-CARR #90081A077)	1
		B/O	RB03309-1	1	LABEL, REMOVE BEFORE FLIGHT		SIGNS NOW	1
		B/O	RB03309-3	2	LABEL, GREASE SLIDES		SIGNS NOW	1
		B/O		1	DART PLACARD	ALUMINUM	RB41011	1
		B/O		1	CRATE ISPM15 CERTIFIED		(SPECIALTY CRATE #CRATE I.D. 29 X 20 X20)	N/S



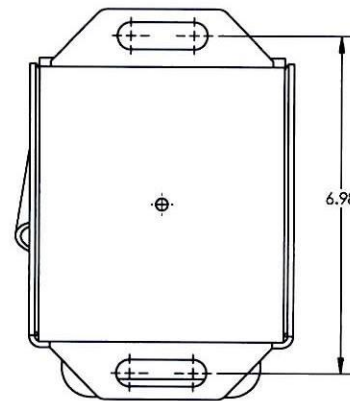
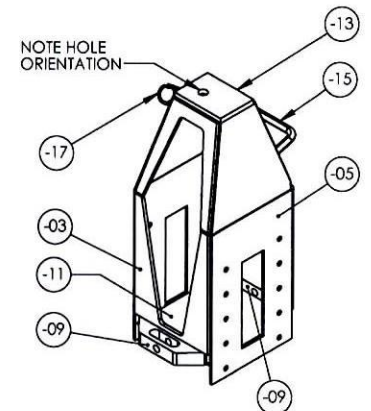
NOTE:
1 UNIT SHOWN, QTY OF 2 REQUIRED

		TITLE	
		GROUND HANDLING WHEELS	
DWG NO.		REV	
RB072610-H-00		5	
MATERIAL		UNLESS OTHERWISE SPECIFIED	
FINISH		DIMENSIONS ARE IN INCHES	
SPEC		XXX ± .005 FRACTIONS ± 1/8	
		XX ± .01 ANGLES ± 9°	
		X ± .1 SURFACES ± 125	
DRAWN BY: PERRITT		1. BREAK ALL SHARP EDGES	
CHECKED: DUERFELD		2. DIMENSIONAL LIMITS APPLY	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER	
QA APPR: LINDSAY		ASME Y14.5M-2009	
APPROVED: GILBERT		USED ON MODEL	
SCALE	1:8	DATE	3/7/2011
		SHEET 1 OF 18	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2		INCREASED HEIGHT BY .50 BELOW THE BEND.	2/23/2012	JAG
3	16-0087	-01 DELETED BEVEL WELD FRONT & BACK, ADDED FILLET WELD 2X, CHD FINISH WAS POWDER COAT FORREST 1-5920 59 YELLOW RIBBON IS POWDER COAT YELLOW FED #13538.	8/1/2016	RJC
4	17-0033	-01 CHD DIM WAS (5.06) IS (5.25); REMOVED DIM (1.02").	2/8/2017	SM

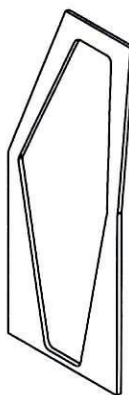
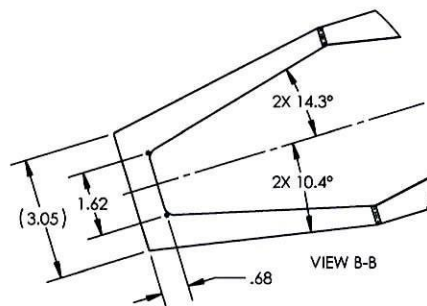
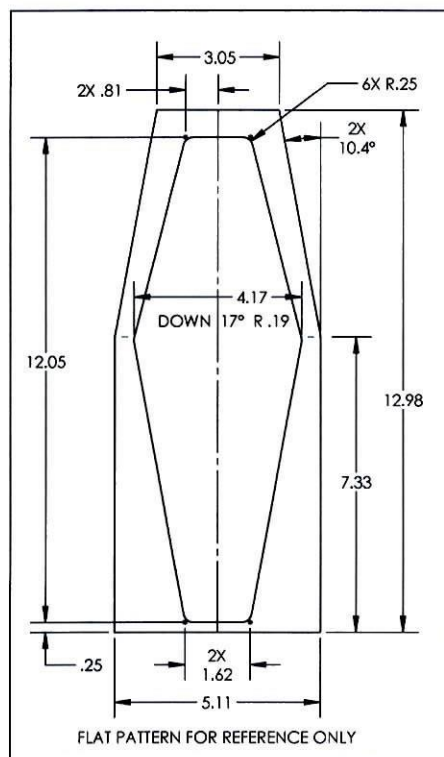


-01
HOUSING WELDMENT

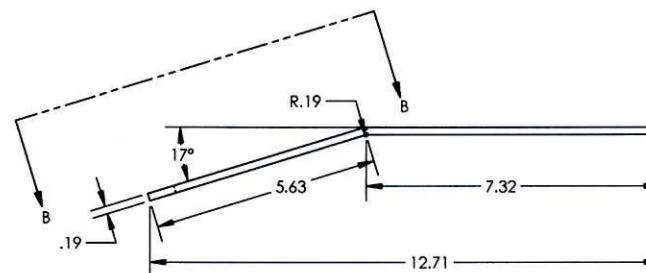
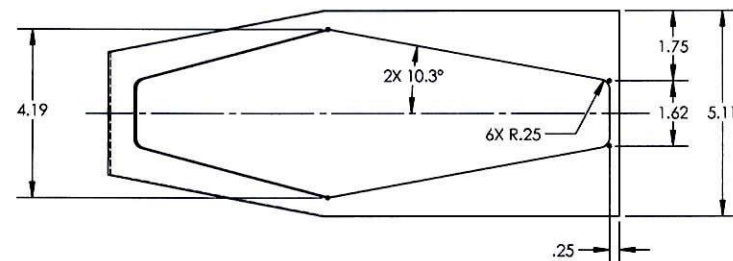
DART AEROSPACE			
TITLE GROUND HANDLING WHEELS			REV 5
DWO NO. RB072610-H-00-01			
MATL FED #13538	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/16 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES ± 125		
FINISH POWDER COAT YELLOW	1. BREAK ALL SHARP EDGES Ø15 ± .45 OR .015R		
SPEC FED #13538	2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
DRAWN BY: PERRITT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009		
CHECKED: DUERFELDT	USED ON MODEL		
OPPS APPR: ANDERSON			
QA APPR: LINDSAY			
APPROVED: GILBERT			
SCALE 1:4	DATE 3/7/2011	SHEET 2 OF 18	

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
2		INCREASED HEIGHT BY .50 BELOW BEND.	2/23/2012	JAG	RW	
4	17-0033	-03 CH'D DIM WAS 12.10 IS 12.05, WAS 3.22 IS (3.05), WAS 7.27 IS 7.33, WAS 13.03 IS 12.98, WAS 14.1 IS 14.3, WAS 10.2 IS 10.4, WAS (2X 10.3) IS 2X 10.4, WAS 7.26 IS 7.32, WAS 5.74 IS 5.63, WAS 12.75 IS 12.71, WAS 3.22 IS 3.05, ADDED DIM .25, 1.62, 1.75, 2X 10.4, 6X R.25, REMOVED DIM (2X .4), 2.56, 2X .81.	2/8/2017	SM	JAG	



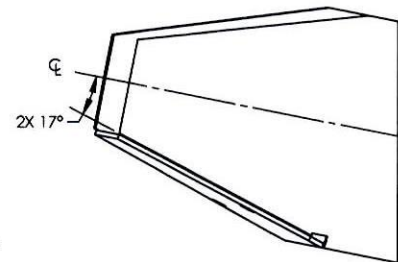
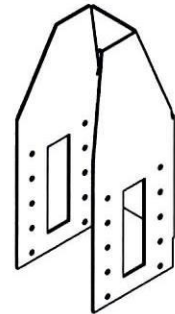
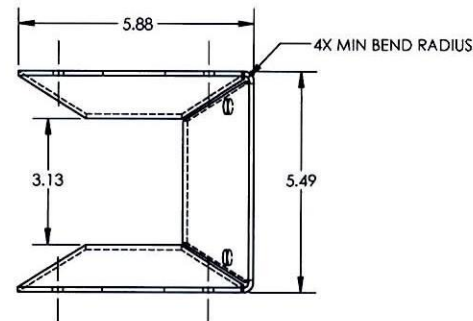
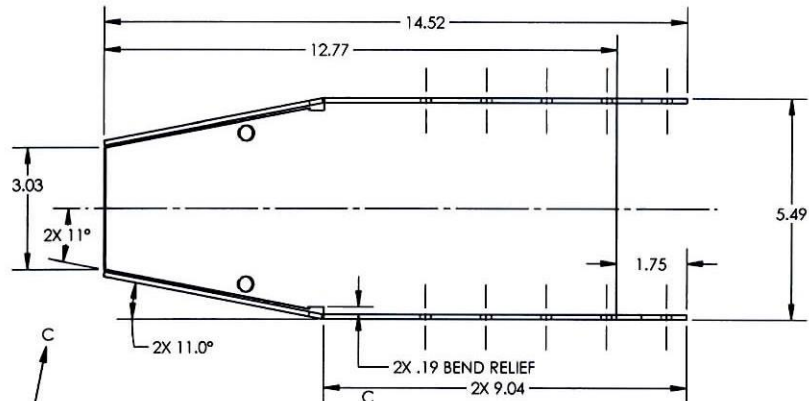
03
FRONT



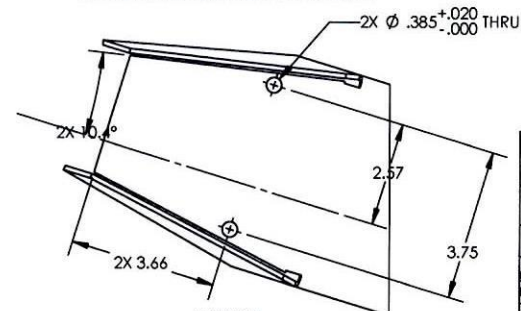
		TITLE	
		GROUND HANDLING WHEELS	
DWG NO.		REV	
RB072610-H-00-03		5	
MATERIAL A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
FINISH SEE -01		DIMENSIONS ARE IN INCHES	
SPEC		FRACTIONS ± 1/8	
DRAWN BY: GILBERT		.XXX ± .010	
CHECKED: DUERFELDT		.XX ± .03	
OPPS APPR: ANDERSON		.X ± .1	
QA APPR: LINDSAY		ANGLES ± 1°	
APPROVED: GILBERT		SURFACES = 125	
SCALE 1:3		1. BREAK ALL SHARP EDGES	
DATE 2/23/2012		.015 ± .005 OR .015R	
SHEET 3 OF 18		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
		USED ON MODEL	

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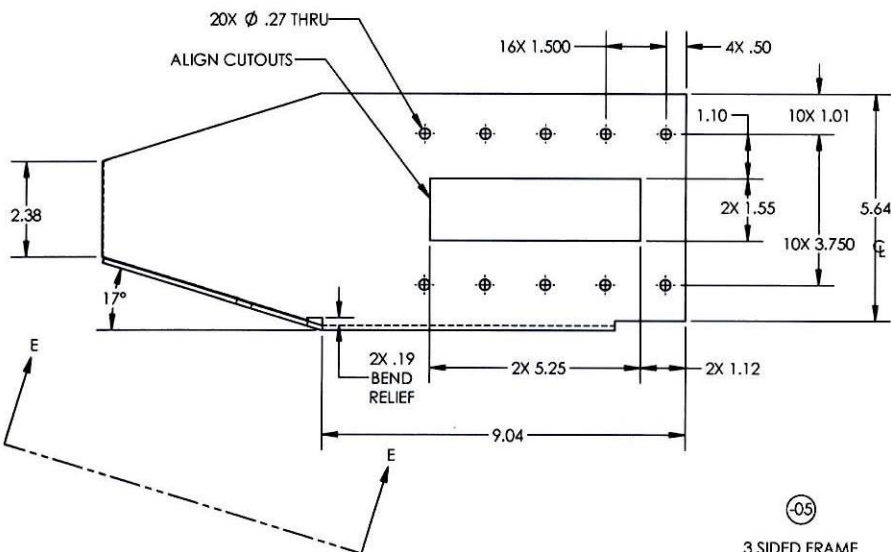
REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2		INCREASED HEIGHT BY .50 BELOW THE BEND.	2/23/2012	RJC
3	16-0087	-05 ADDED DIM 2X .25 TWO PLACES.	8/1/2016	RJC
4	17-0033	-05 CH'D DIM WAS 2X .25 IS 2X .19, WAS 3.24 IS 3.13, WAS 5.30 IS 5.49, WAS 3.20 IS 3.03, WAS 2.43 IS 2.38, WAS 10.4" IS 11", WAS 4X .50 IS 4X .500, WAS 1.01 IS 10X 1.01; REMOVED DIM 1.2", 3.00, 2.75, 1.22, 10.4"; ADDED DIM 2X 11", 5.64, 1.97, 3.75.	2/8/2017	SM
5	17-0144	-05 ADDED DIM 2X Ø.385 +.020 -.000.	6/20/2017	RJC



VIEW C-C
HIDDEN LINES REMOVED FOR CLARITY



VIEW E-E
HIDDEN LINES REMOVED FOR CLARITY



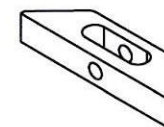
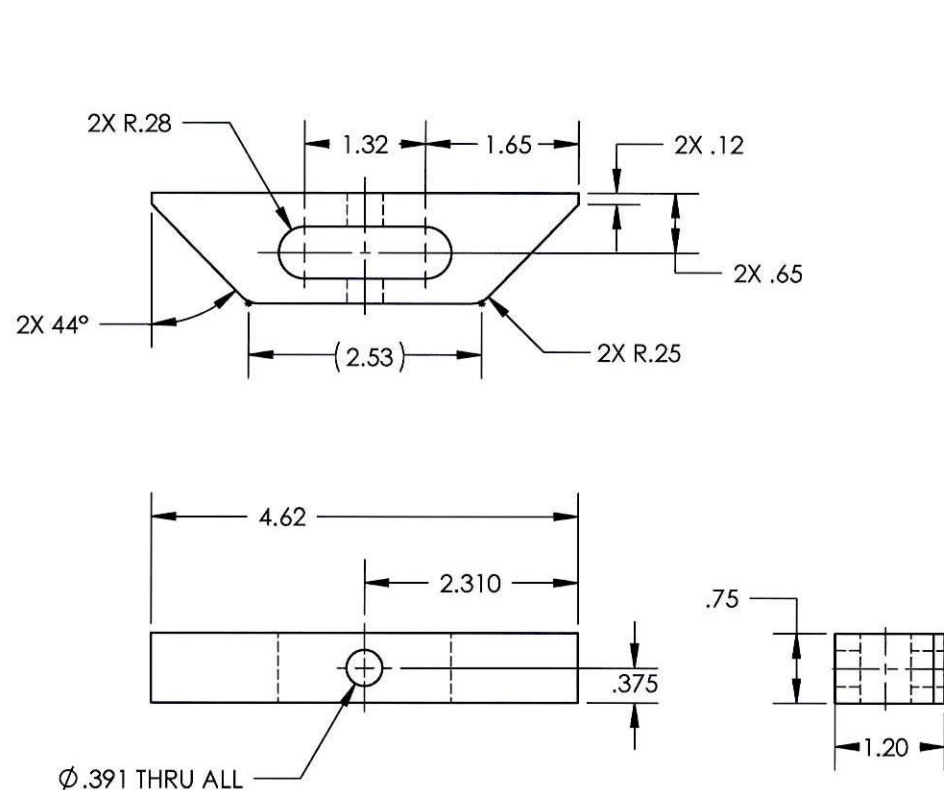
(-05)

3 SIDED FRAME

		TITLE	
		GROUND HANDLING WHEELS	
DWG NO.		REV	
RB072610-H-00-05		5	
MATERIAL A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
FINISH SEE -01		DIMENSIONS ARE IN INCHES	
SPEC		FRACTIONS = 1/8	
DRAWN BY: GILBERT		ANGLES ±1°	
CHECKED: DUERFELDT		SURFACES ±125	
OPPS APPR: ANDERSON		1. BREAK ALL SHARP EDGES	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		3. INTERPRET DIM AND TOL PER	
SCALE 1:3		DATE 3/7/2011	
		SHEET 4 OF 18	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		SHORTENED FROM 5.09 TO 4.62.	3/9/2011	JAG	
2		ADDED 1/4 RADIUS.	2/23/2012	JAG	RW
3	16-0087	-09 CH'D DIMS WAS R.280 IS 2X R.28, WAS 1.316 IS 1.32, WAS .658 IS .66, WAS .120 2X IS 2X .12, WAS .645 IS .65, WAS Ø.391 IS Ø.391 THRU ALL.	8/1/2016	RJC	JAG
4	17-0033	-09 CH'D DIM WAS .65 IS 2X .65, ADDED DIM 1.65; REMOVED DIM (1.27), .66.	2/8/2017	SM	JAG

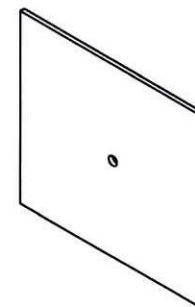
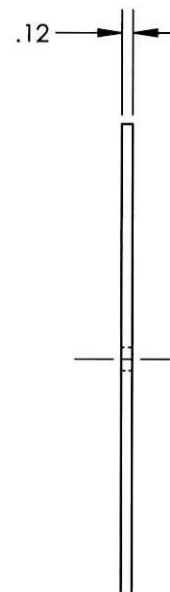
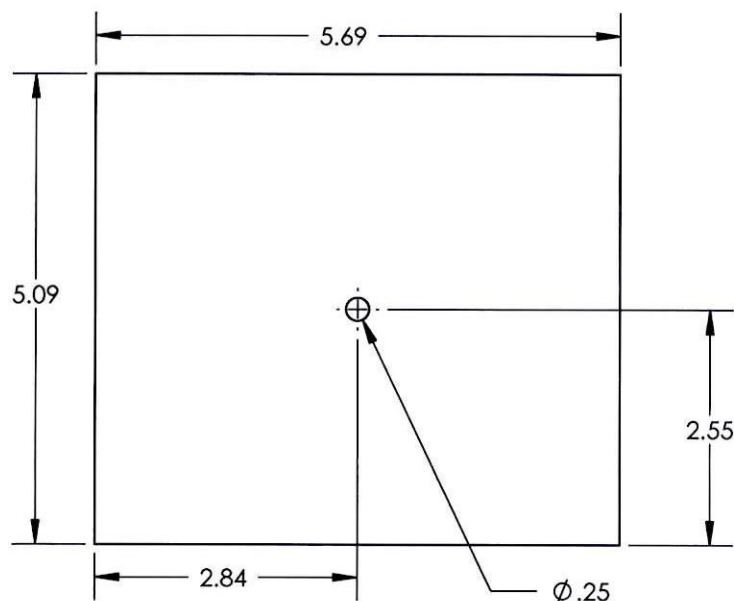


⑨
LATCH BAR

DART AEROSPACE	
TITLE GROUND HANDLING WHEELS	
DWG NO. RB072610-H-00-09	REV 5
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -01	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:2	DATE 3/7/2011 SHEET 6 OF 18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	16-0087	-11 CH'D DIMS WAS 2.844 IS 2.84, WAS 2.52 IS 2.54, WAS Ø.252 IS Ø.25.	8/1/2016	RJC	JAG



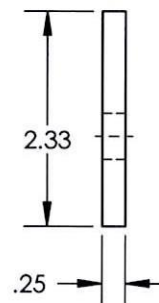
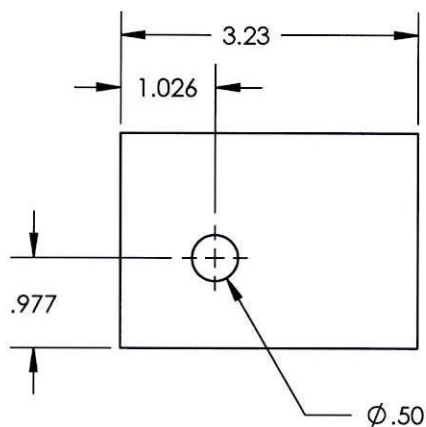
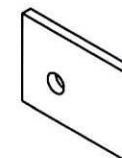
(-11)

BOTTOM

DART AEROSPACE	
TITLE GROUND HANDLING WHEELS	
DWG NO. RB072610-H-00-11	REV 5
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -01	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:2	DATE 3/7/2011 SHEET 7 OF 18

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



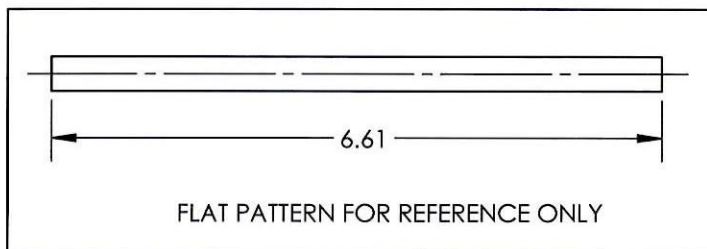
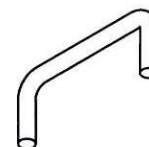
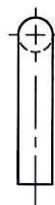
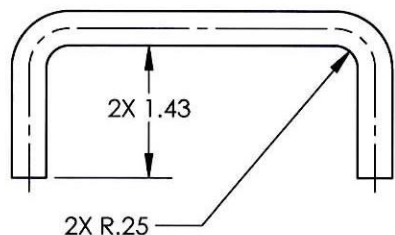
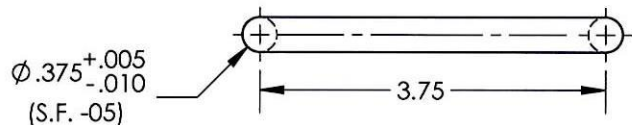
(-13)

TOP

DART AEROSPACE	
TITLE GROUND HANDLING WHEELS	
DWG NO. RB072610-H-00-13	REV 5
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -01	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:2	DATE 3/7/2011 SHEET 8 OF 18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	17-0144	-15 CH'D DIM WAS Ø.38 IS Ø.375 +.005 -.010 (S.F. -05), WAS 1.43 IS 2X 1.43.	6/20/2017	RJC	JAG



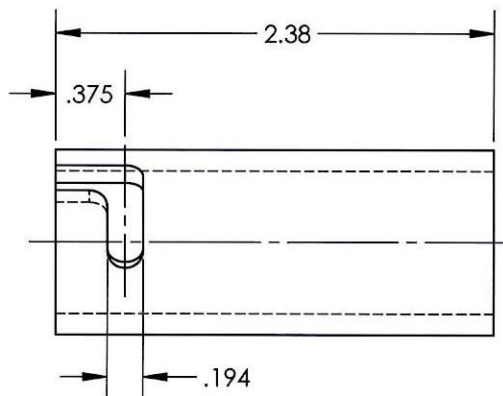
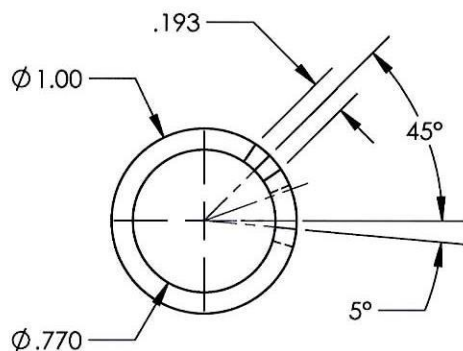
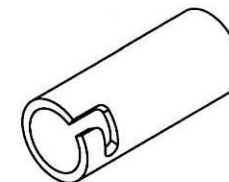
(-15)

HANDLE

DART AEROSPACE	
TITLE GROUND HANDLING WHEELS	
DWG NO. RB072610-H-00-15	REV 5
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -01	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:2	DATE 3/7/2011 SHEET 9 OF 18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



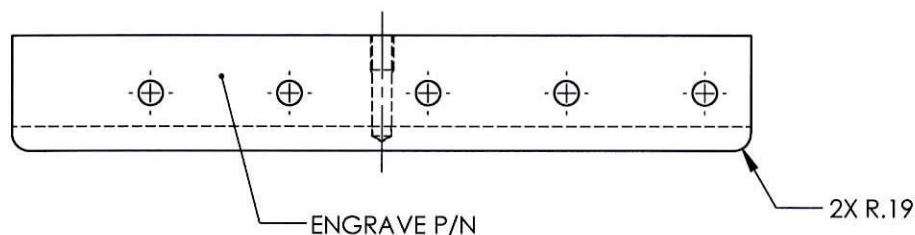
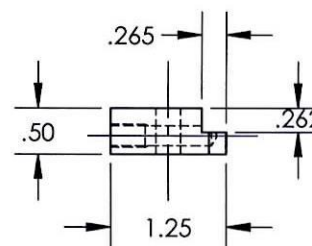
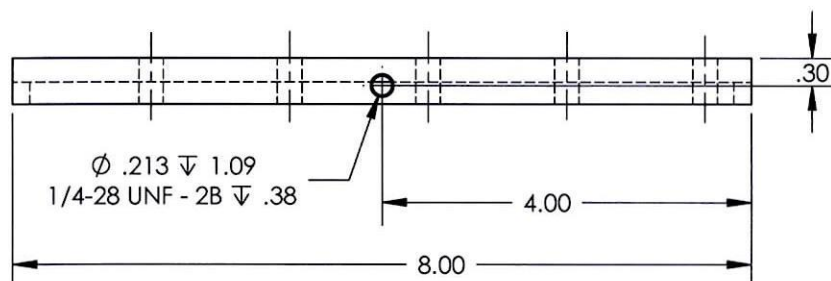
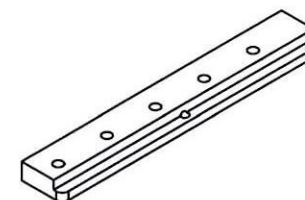
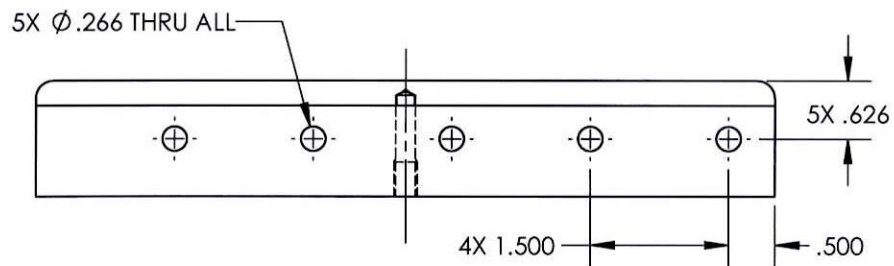
(-17)

LOCK TUBE

DART AEROSPACE	
TITLE GROUND HANDLING WHEELS	
DWG NO. RB072610-H-00-17	REV 5
MAT'L DOM HEAT TREAT FINISH SEE -01 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:1	DATE 3/7/2011 SHEET 10 OF 18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		CH'D TO BLACK ANODIZE FROM GOLD.	2/23/2012	JAG	RW
3	16-0087	-19 DELETED DIMS 3.000, 4.500, AND 6.000. CH'D DIM WAS 1.500 IS 4X 1.500, CH'D ENGRAVE NOTE WAS ENGRAVE PART NO. 3/1 & LETTERS IS ENGRAVE P/N.	8/1/2016	RJC	JAG



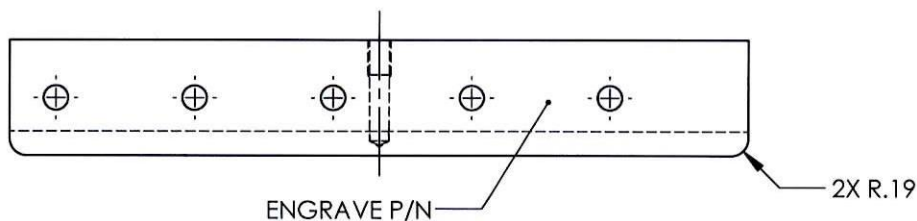
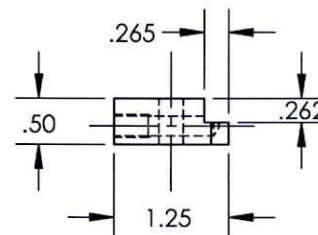
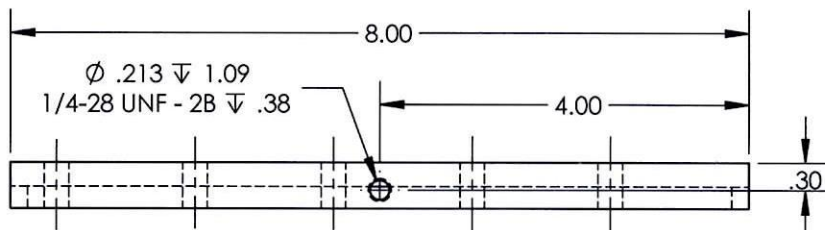
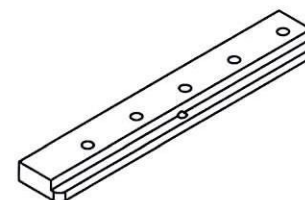
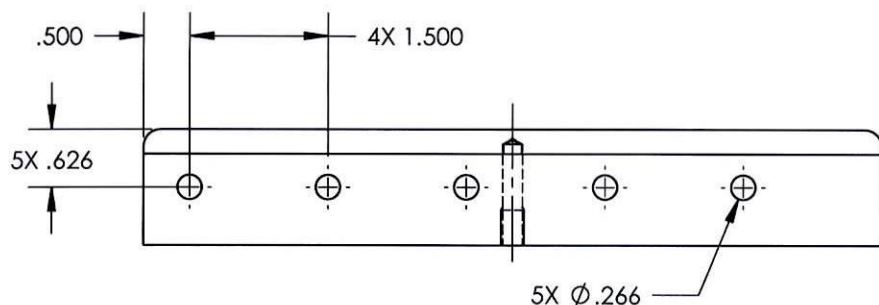
-19

LEFT SLIDE CLAMP

DART AEROSPACE	
TITLE GROUND HANDLING WHEELS	
DWG NO. RB072610-H-00-19	REV 5
MAT'L 6061 HEAT TREAT FINISH BLACK ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS II	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$.5° .X $\pm$.1 SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: PERRITT CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
SCALE 1:2	DATE 3/7/2011
SHEET 11 OF 18	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		CH'D TO BLACK ANODIZE FROM GOLD.	2/23/2012	JAG	RW
3	16-0087	-21 DELETED DIMS 3.000, 4.500, AND 6.000. CH'D DIM WAS 1.500 IS 4X 1.500, CH'D ENGRAVE NOTE WAS ENGRAVE PART NO. 3/1 & LETTERS IS ENGRAVE P/N.	8/1/2016	RJC	JAG



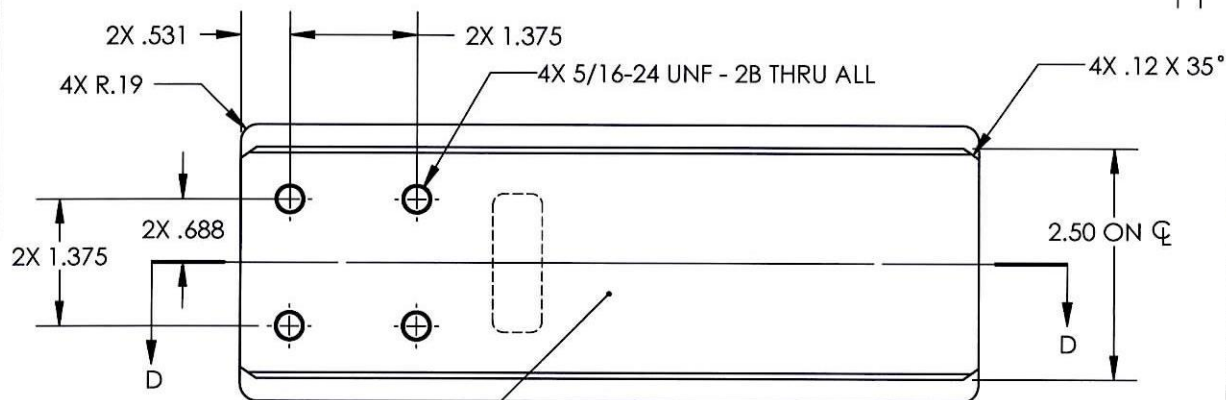
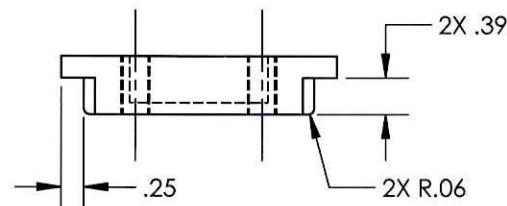
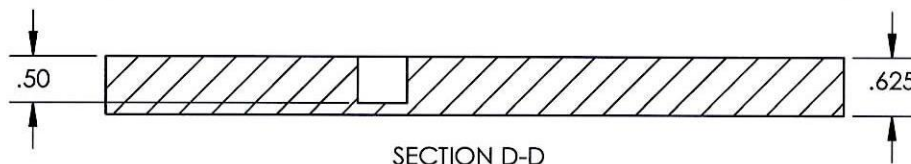
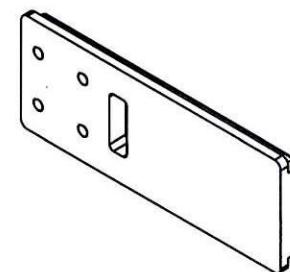
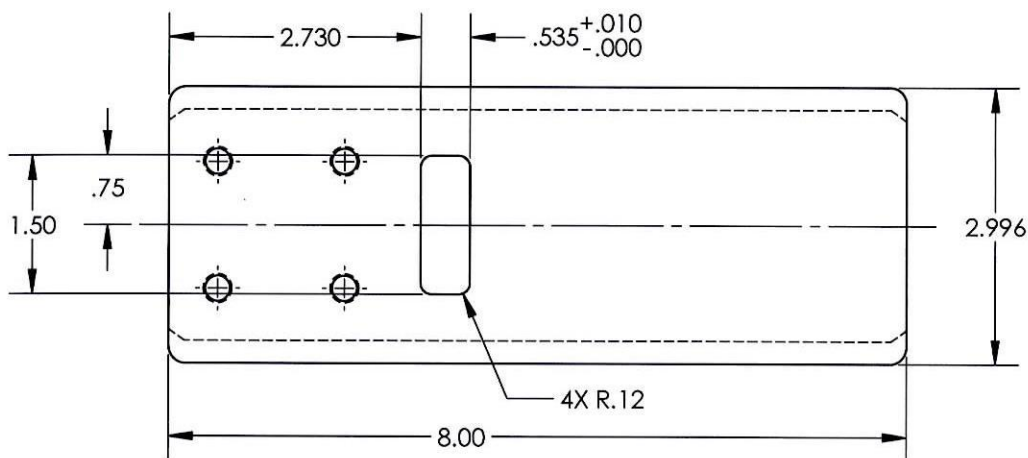
(-21)

RIGHT SIDE CLAMP

DART AEROSPACE	
TITLE GROUND HANDLING WHEELS	
DWG NO. RB072610-H-00-21	REV 5
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm .005$ FRACTIONS $\pm 1/8$
FINISH BLACK ANODIZE	.XX $\pm .01$ ANGLES $\pm 5^\circ$
SPEC MIL-A-8625F, TYPE II, CLASS II	.X $\pm .1$ SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:2	DATE 3/7/2011
SHEET 12 OF 18	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		5/16-18 CHANGED TO 5/16-24, ADDED R.06 TO EDGES.	3/9/2011	JAG
2		CH'D TO BLACK ANODIZE FROM GOLD.	2/23/2012	JAG
3	16-0087	-23 CH'D DIM WAS .525 IS .535 +.010-.000.	8/1/2016	RJC



ENGRAVE P/N

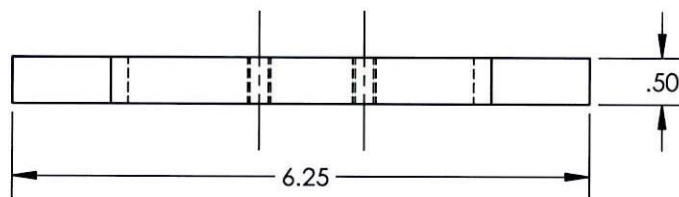
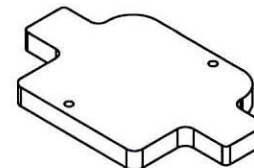
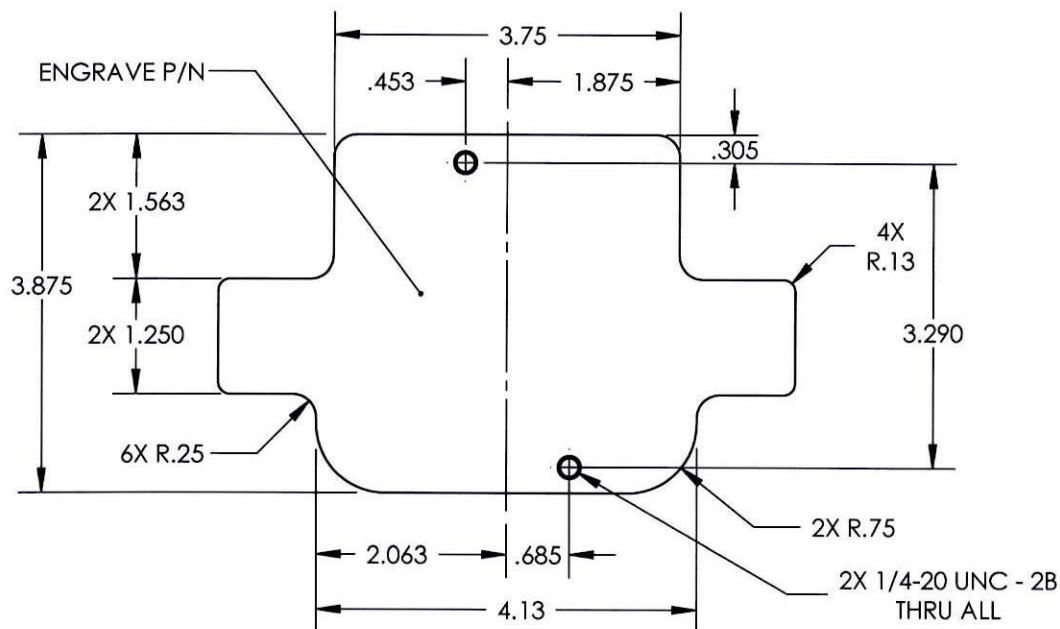
(-23)

SLIDE

DART AEROSPACE	
TITLE GROUND HANDLING WHEELS	
DWG NO. RB072610-H-00-23	REV 5
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK ANODIZE	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625F, TYPE II, CLASS II	.X ± .1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:2	DATE 3/7/2011
SHEET 13 OF 18	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	16-0087	-25 CH'D FINISH WAS POWDER COAT FORREST T-5920 S9YELLOW RIBBON IS POWDER COAT YELLOW FED #13538.	8/1/2016	RJC	JAG
4	17-0033	-25 REMOVED DIM 3.125; CH'D DIM WAS 4X R.25 IS 6X R.25.	2/8/2017	SM	JAG

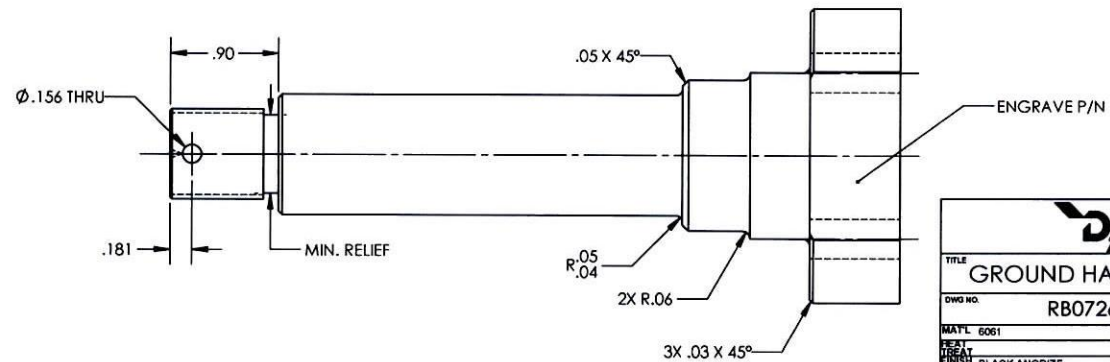
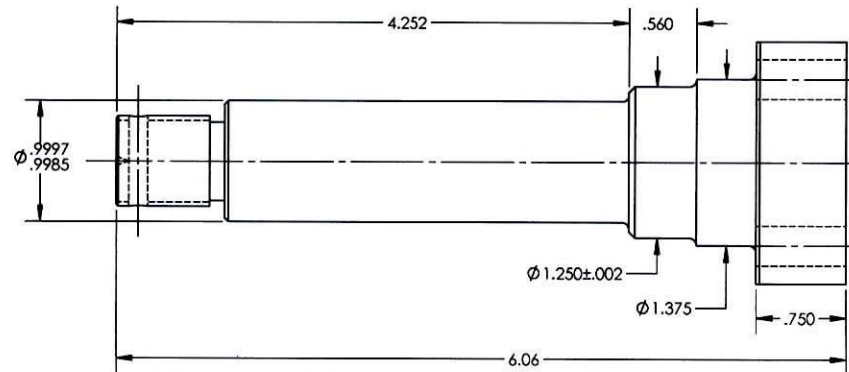
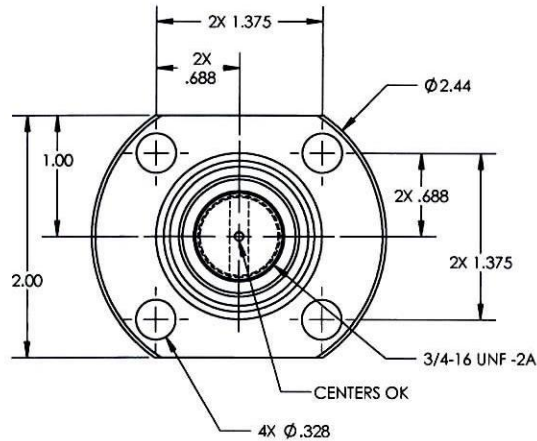


(-25)
JACK PLATE

DART AEROSPACE	
TITLE GROUND HANDLING WHEELS	
DWG NO. RB072610-H-00-25	REV 5
MAT'L 4140/4142 HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: PERRITT CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL	
SCALE 1:2	DATE 3/7/2011 SHEET 14 OF 18

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		CHANGED LENGTH FROM 5.282 TO 4.06.	3/9/2011	JAG
2		CORRECTED 3/4-16 UNF CALL OUT, CH'D BLACK ANODIZE FROM GOLD.	2/23/2012	JAG
3	16-0087	-27 CH'D DIMS WAS .772 IS .77, WAS .125 IS .13, WAS Ø.650 IS Ø.65, CH'D ENGRAVE NOTE WAS ENGRAVE PART No. 3/16 LETTERS IS ENGRAVE P/N.	8/2/2016	RJC
4	17-0033	-27 CORRECTED REV 3 NOTES, REPLACE DIMS Ø.65, .13, .77 WITH .90, MIN THREAD RELIEF.	2/8/2017	SM



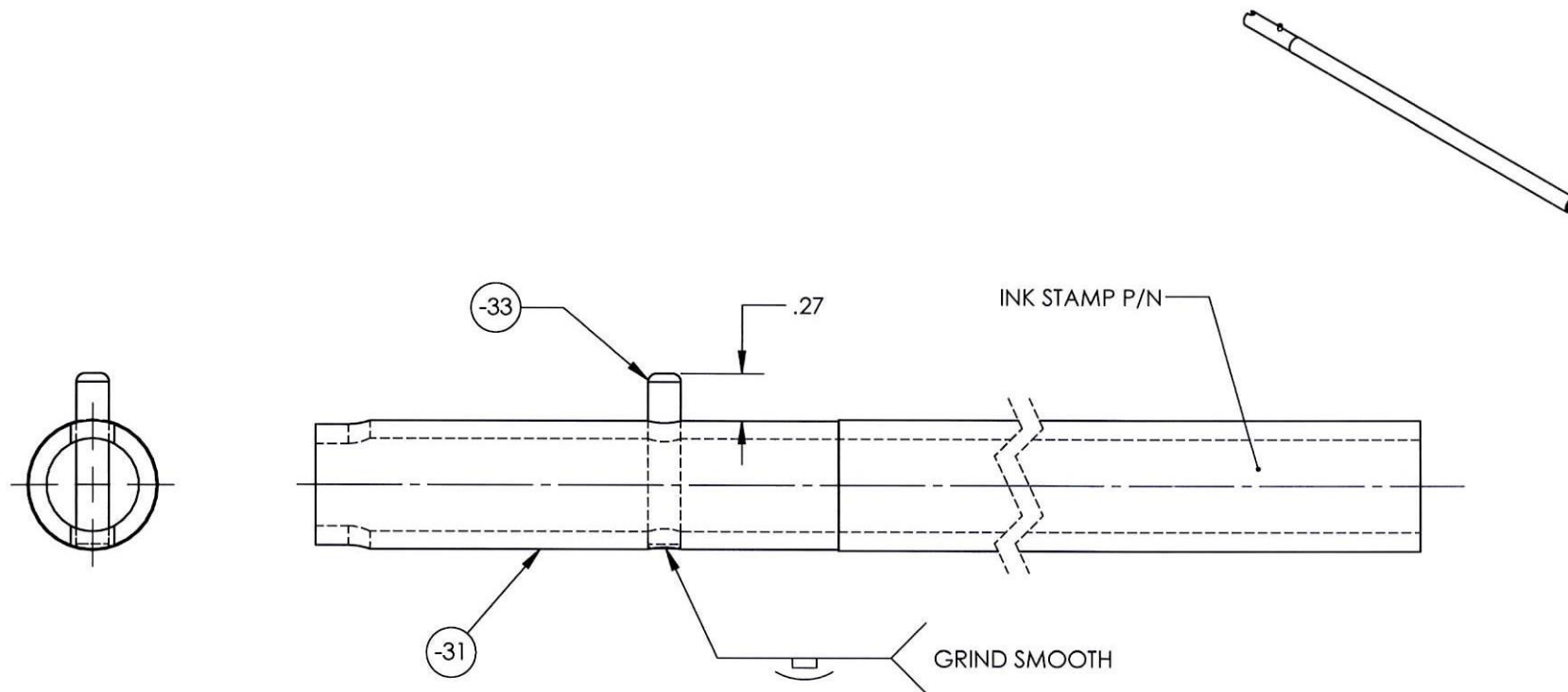
(-27)

SPINDLE

DART AEROSPACE	
TITLE GROUND HANDLING WHEELS	
DWG NO. RB072610-H-00-27	REV 5
MATL 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FINISH BLACK ANODIZE	.XXX ± .005 FRACTIONS ± 1/8
SPEC MIL-A-8625F, TYPE II, CLASS II	.XX ± .01 ANGLES ± 5°
DRAWN BY: PERRITT	.X ± .1 SURFACES ± 125
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES Ø15 ± .05 OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL
SCALE 1:1	DATE 3/7/2011
SHEET 15 OF 18	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	16-0087	-29 CH'D FINISH WAS POWDER COAT FORREST T-5920 S9YELLOW RIBBON IS POWDER COAT YELLOW FED #13538.	8/1/2016	RJC	JAG
4	17-0033	-29 ADDED NOTE 'INK STAMP P/N'.	2/8/2017	SM	JAG

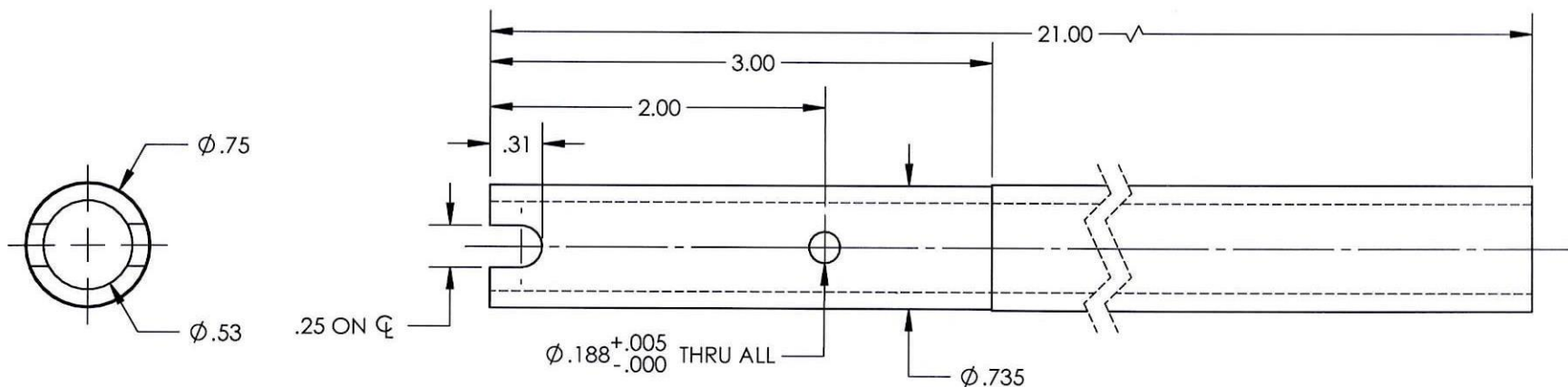


(-29)
HANDLE BAR WELDMENT

DART AEROSPACE	
TITLE GROUND HANDLING WHEELS	
DWG NO. RB072610-H-00-29	REV 5
MAT'L HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/√
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:4	DATE 3/7/2011 SHEET 16 OF 18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1			3/9/2011	JAG	
3	16-0087	-31 CH'D DIM WAS Ø.188 IS Ø.188 THRU ALL, CH'D ENGRAVE NOTE WAS ENGRAVE PART No. "RB072610-H-29, 3/16 LETTERS IS ENGRAVE "RB072610-H-29".	8/1/2016	RJC	JAG
4	17-0033	-31 REMOVED NOTE "INK STAMP "RB072610-H-29".	2/8/2017	SM	JAG
5	17-0144	-31 CH'D DIM WAS Ø.188 THRU ALL IS Ø.188 +.005 -.000 THRU ALL.	6/20/2017	RJC	JAG



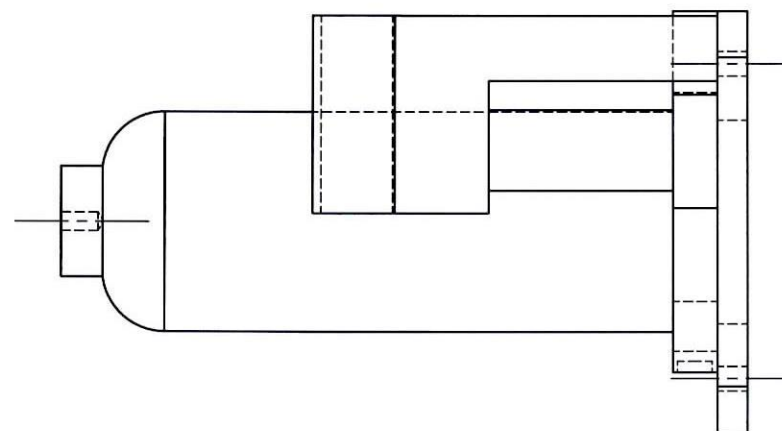
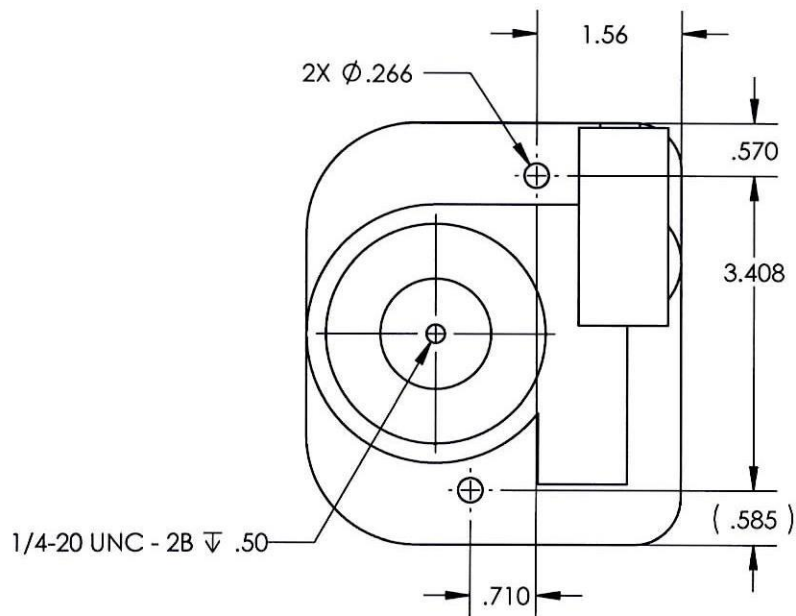
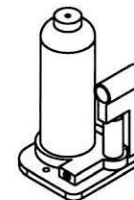
(-31)

HANDLE BAR

DART AEROSPACE	
TITLE GROUND HANDLING WHEELS	
DWG NO. RB072610-H-00-31	REV 5
MAT'L DOM HEAT TREAT FINISH SEE -29 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:4	DATE 3/7/2011
SHEET 17 OF 18	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	16-0087	-35 DELETED TACK IN TWO PLACES WELD CALLOUT.	8/1/2016	RJC	JAG
4	17-0033	-35 CH'D DIM WAS 1.563 IS 1.56.	2/8/2017	SM	JAG



(-35)

3 TON
HYDRAULIC JACK

DART AEROSPACE	
TITLE GROUND HANDLING WHEELS	
DWG NO. RB072610-H-00-35	REV 5
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$.5° .X $\pm$.1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:2	DATE 3/7/2011 SHEET 18 OF 18



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
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Fax: (613) 678-3956

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Date: Jul 19, 2018
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Shipped By: pick up	Ship Date: Jul 19, 2018

Description	Bin Loc	Unit	Quantity ordered	Quantity shipped	Quantity on B/O
Refurbishing of Ground Handling Wheel, p/n RB072610-H-00			1	1 ✓	
					DAS 38 9-89
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The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
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SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	P.O. Number
1SET	RB072610-H-00	GROUND HANDLING WHEEL	40172

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A blue ink signature of Jan Norris, consisting of a stylized first name and a last name.

Jan Norris

Vankleek Hill, July 19, 2018

DAS
38
9-89